

Work Order ID 56813

Wednesday, March 10, 2010 1:44:48 PM



Page 1

Item ID: D3389-1

Revision ID:

Item Name: Web

Start Date: 3/10/2010 Start Qty: 4.00

Required Date: 3/17/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: JMF

Date: 10-3-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3389

Rev D

100



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Cut to length as per Dwg D3389 2-Drill pilot holes using DT8785 as per Dwg D3389 3-Open holes to finish size as per Dwg D3389 4-Deburr

4 - - AWM 10-3-12
P12 →

110



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8 o/g h

④

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo




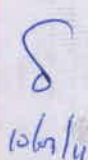
0.00

④

110/3/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3309-1 PAR #: _____ Fault Category: sketches NCR: Yes No DQA: 1 Date: 10/3/15
 Resolution: Scrap Disposition: scrap QA: N/C Closed: 1 Date: 10/03/16

NCR: <u>56813</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/15	# 100	Qty x1 Fanno Damaged at top of "I" beam latches. R.L. handling		Scrap & destroy web look like it was hit during unloading or when placed in Rack.	M 10/3/15	 10/07/16		 10/07/16

NOTE: Date & initial all entries

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Item ID: D3389-1

Accept

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Start Date: 3/10/2010 Start Qty: 4.00

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

REX4

0

10/03/15

140

Identify as per dwg & Stock Location: 46.

0.00



Packaging

Memo

0.00

Packaging

21

u

10/3/15

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/16

R 10-3-14

7

Picklist Print

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Work Order ID: 56813



Parent Item: D3389-1



Parent Item Name: Web

Comments:

IPP Rev:A 05.08.31 New issue KJ/JLM
 IPP Rev:B 06-02-08 As per Rev C JLM
 IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Start Date: 3/10/2010

Required Date: 3/17/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ D2500-3-100	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 175.0000	Remaining 4.0000	Qty	Date	Status
Ext'n - 1" Beam Web 4"												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	175	
40196	16	
<u>51957</u>	159	

11/93/15

DART AEROSPACE LTD		Work Order: 56813
Description: 10 EB/412 Flat Skid DT8785	Part Number: D3389-1	
Inspection Dwg: D3389 Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
90.38	QS118	90.38	/			
82.75	± .03	82.75	/			
79.25		79.25	/			
71.25		71.25	/			
65.50		65.52	/			
2.000	± .001	2.000	/			
2.000		2.000	/			
0.813		0.810	/			
5.250		5.250	/			
20.00	± .003	20.00	/			
4.000	± .001	4.000	/			
4.000		4.000	/			
4.000		4.000	/			
4.000		4.000	/			
4.000		4.000	/			
2.000		2.000	/			
2.000		2.000	/			
28.00	± .003	28.00	/			
4.000	± .001	4.000	/			
4.000		4.000	/			
4.000		4.000	/			
4.000		4.000	/			
4.000		4.000	/			

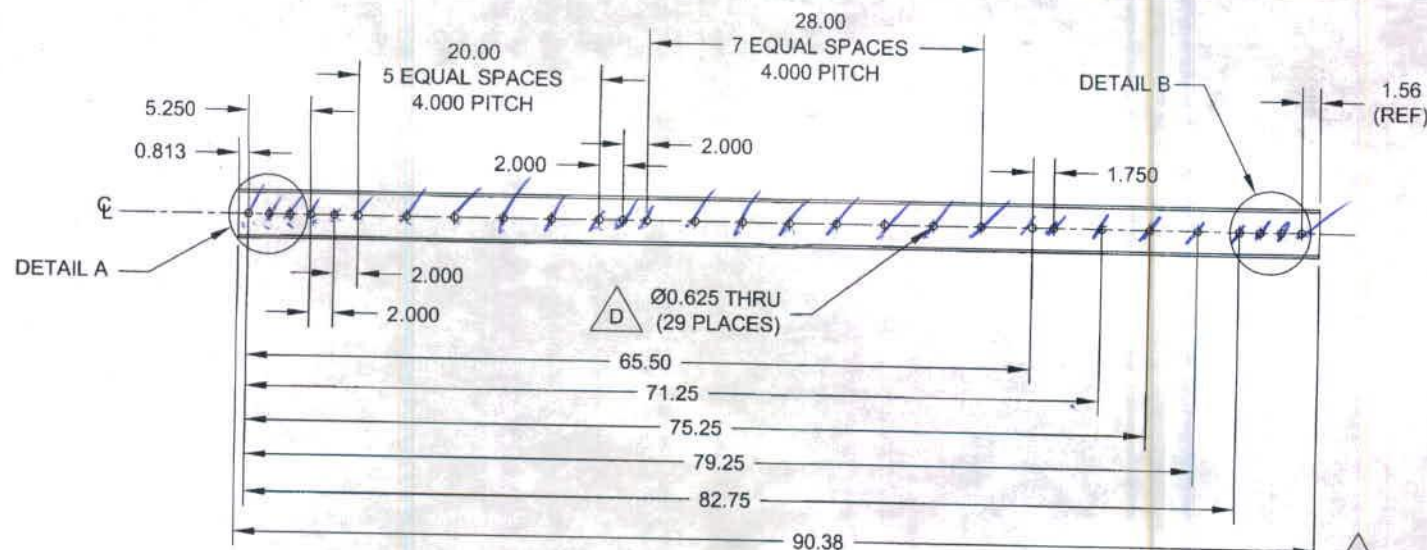
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-3-11	Date: 10/3/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

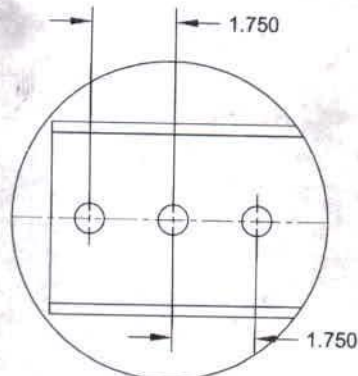
ORD → App → DTXXXX

2 → DT 8785 x1

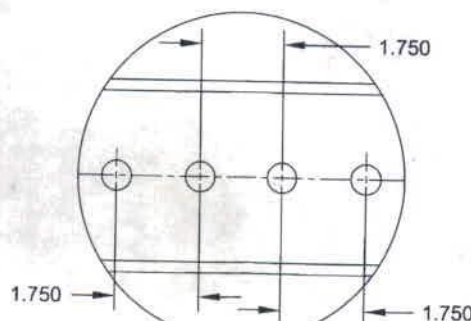
.187 → .250 THK.



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

REFERENCE ONLY

#56813

REV.	DESCRIPTION	BY	DATE
D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
DESIGN	DART AEROSPACE USA, INC		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO.	REV. D	
MFG. APPR.	D3389	SHEET 1 OF 1	
APPROVED	TITLE	SCALE	
DE APPR.	412 WEB	1:10	
DATE	07.10.09	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

